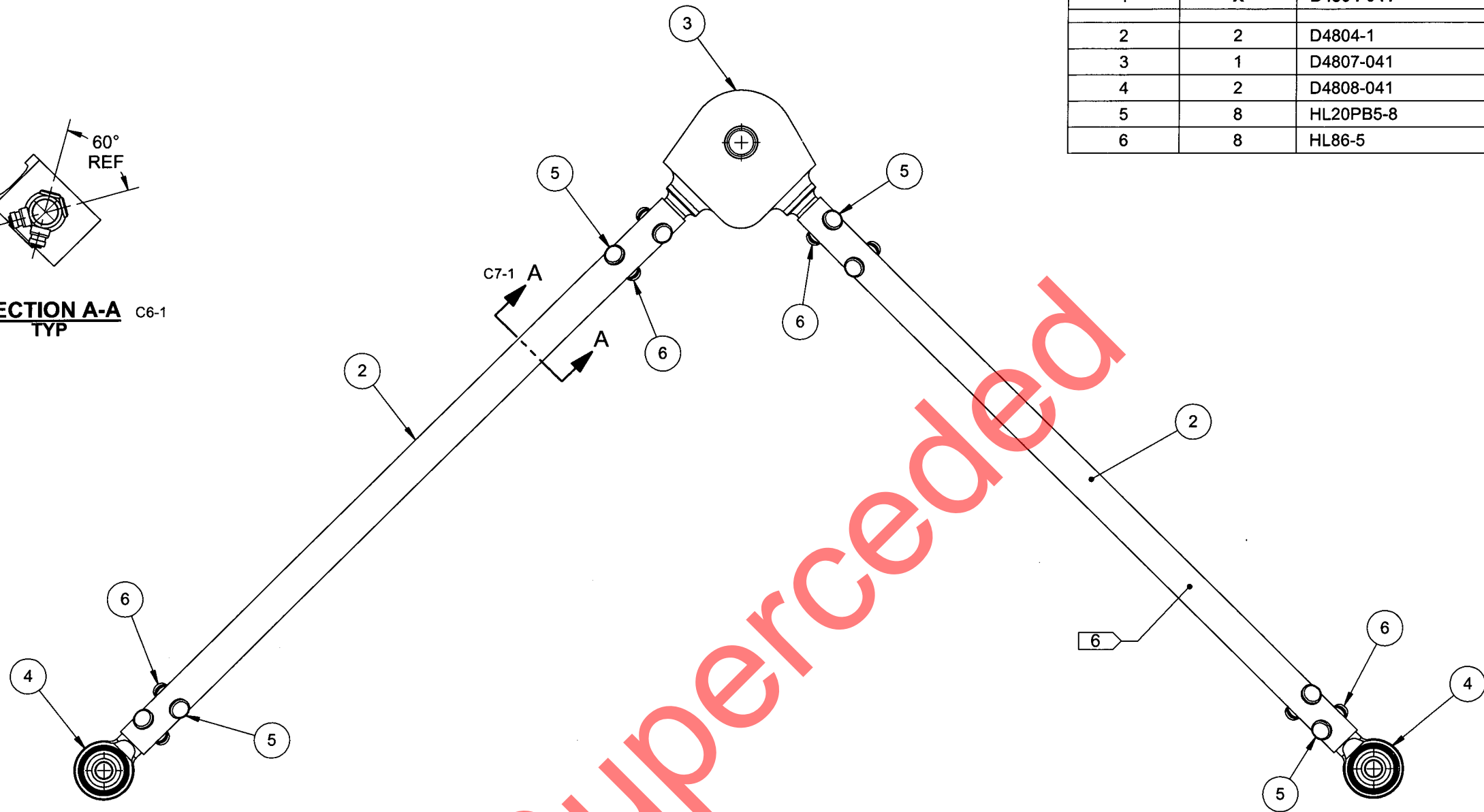


SECTION A-A
TYP C6-1



D4804-041 BIPOD ASSEMBLY, AFT

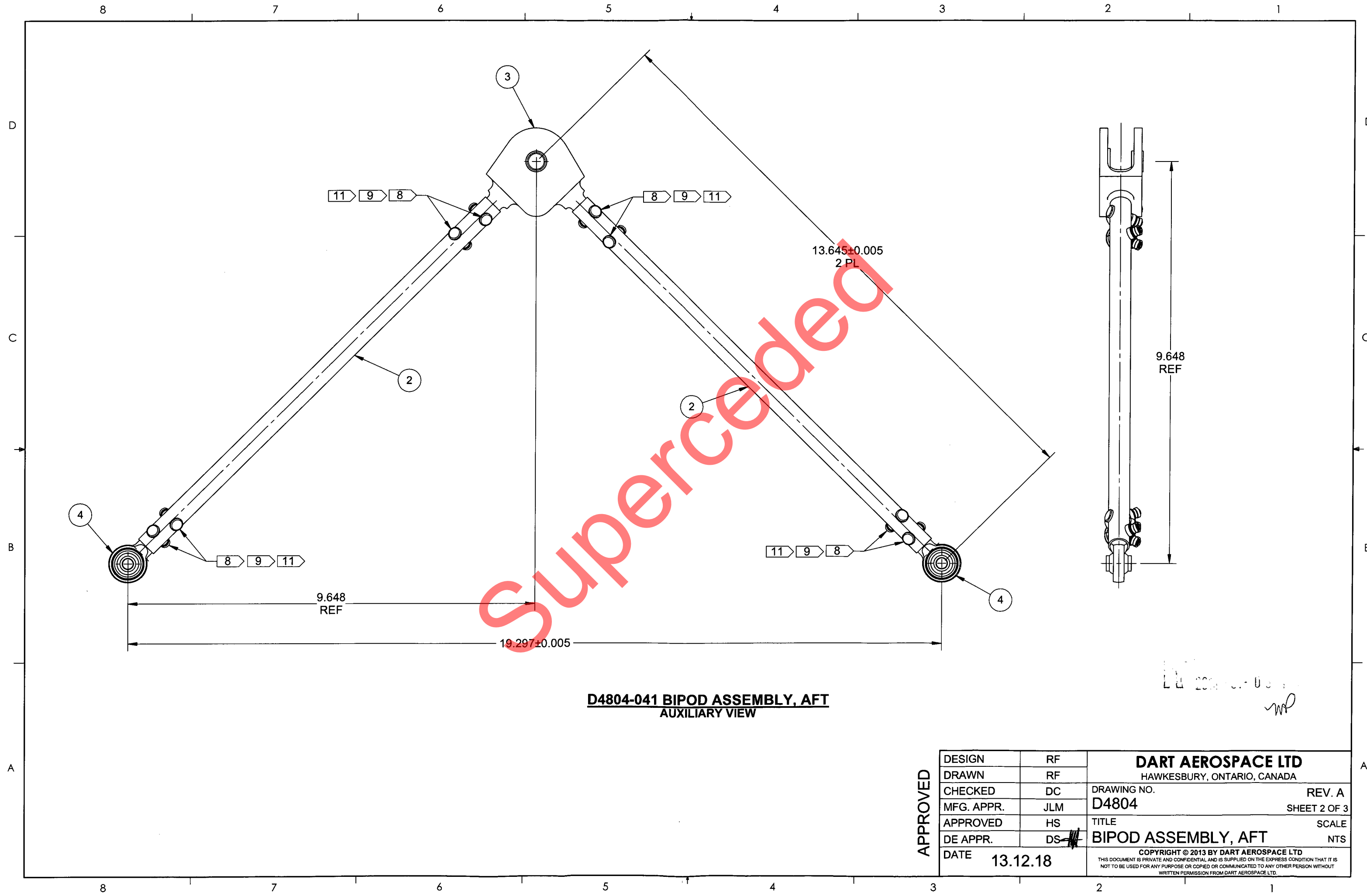
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4804-041	BIPOD ASSEMBLY, AFT
2	2	D4804-1	STRUT
3	1	D4807-041	SUPPORT ASSEMBLY
4	2	D4808-041	ROD END BEARING ASSEMBLY
5	8	HL20PB5-8	HI-LOK PIN
6	8	HL86-5	HI-LOK COLLAR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) ALIGN PILOT HOLES IN D4807-041 WITH PILOT HOLES IN D4804-1.
ALIGN PILOT HOLES IN D4808-041 WITH PILOT HOLES IN D4804-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9954
- 9) INSTALL PIN/COLLAR AND ROD END WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9954
- 11) INSTALL HL20PB5-8 HI-LOK IN ORIENTATION SHOWN

APPROVED

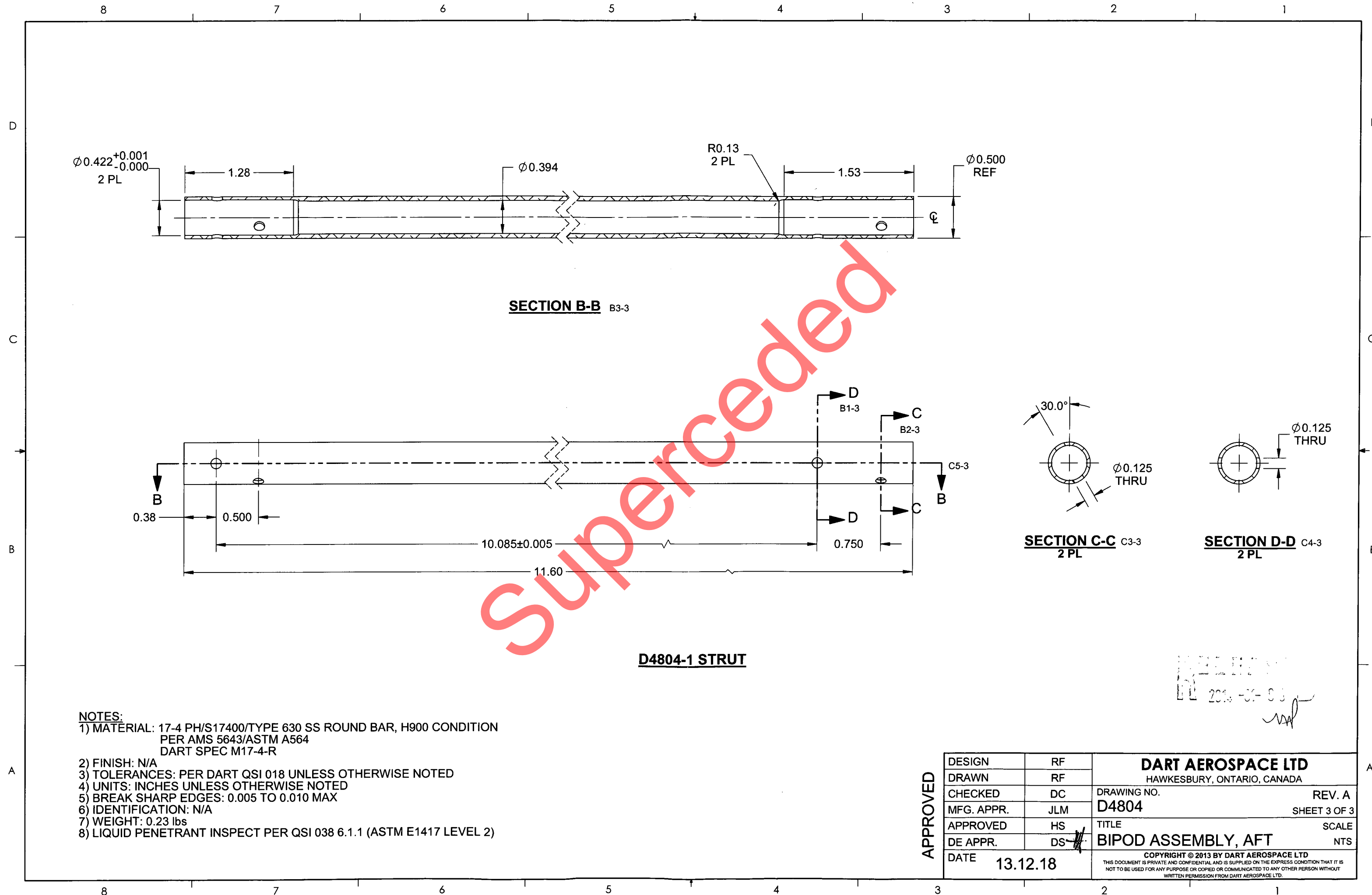
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4804	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
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D4804-041 BIPOD ASSEMBLY, AFT
AUXILIARY VIEW

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DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4804	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
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NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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MFG. APPR.	JLM	SHEET 3 OF 3	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
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